



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-141

Job Sheet 207491



Part No: D3121-141

Job Qty: 12 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Due Date: 3/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev: Pick: A 04.02.18 New issue KJ/DS IPP Rev: B ECN 1060 07-11-12 DD verified by: EC
IPP Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified By: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	3/13/20		0.00	1.36	Bandsaw - 1		APR 20/03/09
110	HAAS 4 Axis - B4B	12 pcs	3/13/20		0.47	23.53	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		APR 20/03/13
120	QC 2	12 pcs	3/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		APR 20/03/13
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S262123



Part: D3121-141

Job No: 207491

Serial No/Batch: S262123

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/09/20

Plex 2/27/20 8:49 AM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
130 QC 8	12 pcs	3/13/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	De 20-03-13
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - 2 - B4B	12 pcs	3/13/20	0.00 0.34	Small Fab - 1 - B4B	DAS 58 MAR 16 2020
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	12 pcs	3/13/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	12 pcs <i>6 pcs M.D.</i>	3/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	12 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blanks: (1.250" x 2.000") 6.600" long Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - QC8- Inspect parts - second check) 140 - (Small Fab) Assemble D3121-141 as per Dwg D3121. 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)						

015018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	6.6000 ft (.55 ea)	100-Bandsaw - 1	5158301 = 7.08
D3121-21 <i>ST018</i>	Bolt	12 pcs (1 ea)	140-Small Fab - 2 - B4B	5228846
D3121-241 <i>ST019</i>	Bearing Assembly	12 pcs (1 ea)	140-Small Fab - 2 - B4B	5256987 x4 5286937
				5249549

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.250X2.000	7	9	0
140-Small Fab - 2 - B4B	D3121-21	12	15	0
	D3121-241	12	23	0

Part Specifications

Specifications could not be found.

Plex 2/27/20 8:49 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 207491
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.393	✓		micrometer	67173765
0.75	+/-0.030	.749	✓		vernier	B17321453
0.375	+/-0.010	.375	✓		vernier	B17321453
2.14	+/-0.030	2.135	✓		vernier	B17321453
1.96	+/-0.030	1.971	✓		vernier	B17321453
0.280	+/-0.010	.284	✓		vernier	B17321453
3.330	+/-0.010	3.335	✓		vernier	B17321453
3.630	+/-0.010	3.632	✓		vernier	B17321453
R0.25	+/-0.030	R.250	✓		Gaborit	(ref)
R0.375	+/-0.010	R.375	✓		Gaborit	(ref)
Ø0.201	+/-0.010	.200	✓		linguist	(ref)
0.100	+/-0.010	.107	✓		vernier	B17321453
4.580	+/-0.010	4.580	✓		high gauge	31006
6.18	+/-0.030	6.190	✓		vernier	B17321453
5.89	+/-0.030	5.885	✓		vernier	B17321453
0.080	+/-0.010	.083	✓		vernier	B17321453
0.300	+/-0.010	.306	✓		vernier	B17321453
30°	+/-0.1°	30°	✓		Gaborit	(ref)
R0.25	+/-0.030	R.250	✓		Gaborit	(ref)
0.130	+/-0.010	.130	✓		micrometer	67173765
0.664	+/-0.010	.666	✓		high gauge	31006
0.381	+/-0.010	.381	✓		vernier	B17321453
0.201	+/-0.010	.198	✓		vernier	B17321453
0.400	+/-0.010	.392	✓		vernier	B17321453
0.580	+/-0.010	.582	✓		vernier	B17321453
100°	+/-0.1°	100°	✓		Gaborit	(ref)
0.032	+0.000/-0.010	.030	✓		micrometer	896010

Measured by: M.M. Jones	Audited by: B.A.	Preliminary Approval:
Date: 2029/03/10	Date: 20-03-13	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	
F	13.10.22	Tolerance revised for Ø0.201 dimension	KJ	